












Date: Wednesday, 15/08/2007 4:04:26 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GHW MOD KIT
Jot Number	: 33958		
Estimate Number	: 11182		
P.C. Number	: <i>N/A</i>	Part Number	: D350615041
This Issue	: 15/08/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D350-615
Prsht Rev.	: <i>NC</i>	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 33390	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 22/09/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	100 Um: Each
Comment	: Est Rev:K Removed Manufacturing 05-12-05 JLM		
Additional Product			
Jot Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
			<i>(100)</i>
Comment: DOCUMENT CONTROL Photocopy bluefile and type labels (2 GHW Kits per box) as per PPP D350-615-041 CHG003 <i>KS 07.07.05</i>			
2.0	33958A	"T" HANDLE ASSEMBLY	
			
Comment: Sub-Component "T" HANDLE ASSEMBLY D2282-041 B <i>B33958A</i>			
3.0	33958B	SADDLE ASSEMBLY	
			
Comment: Sub-Component SADDLE ASSEMBLY D2282-043 B <i>B33958B</i>			
4.0	D30153	Lock Nut	
			
Comment: Qty.: 3.0000 Each(s)/Unit Total: 300.0000 Each(s) Pick: <i>25</i> Qty Part Number Description Batch <i>33546</i> 3 D3015-3 5/16 Locknut <i>33423</i> <i>50</i>			
5.0	D30155	SS Nylock Nut 7/16	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s) Pick: <i>7X</i> Qty Part Number Description Batch <i>33424</i> 1 D3015-5 7/16 Locknut <i>21524</i> <i>7/10/450</i>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MOD KIT

Job Number: 33958

Part Number: D350615041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

51618015C

SS Bolt 5/16-18 1.5" L



Comment: Qty.: 3.0000 Each(s)/Unit Total: 300.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 5/16-18-015C 5/16 Bolt 1.5 Long

200
M103/65

SP 100 29 x
M105 024 M105 403

7.0

516WC

SS Flat Washer 5/16



Comment: Qty.: 12.0000 Each(s)/Unit Total: 1200.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 5/16WC 5/16 Flat Washer

900
M105024

SP
300 + 66 x

8.0

71614050C

SS Bolt 7/16 5" Long



Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 7/16-14-050C 7/16 Bolt 5.0 Long

50
M105432

M105028
7/10/4 SP

9.0

716WC

SS Flat Washer 7/16



Comment: Qty.: 2.0000 Each(s)/Unit Total: 200.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 7/16wc 7/16 Washer

1 D2282-041(Ref)

"T" Handle Assembly

1 D2282-043 (Ref)

Saddle Assembly

M102977
3102977
B 339 58 4
B 339 58 6

M105024 200

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D2282-041 with D2282-043 as per Dwg D350-615 Only engage one thread on three 5/16-18-015C bolts

M 07/10/16 (110)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 8/14/18

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MOD KIT

Job Number: 33958

Part Number: D350615041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

E 07/10/17 (110) *com FEO*

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-615-041

Location:

PPP Rev:

E 07/10/18 (110)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(110) 07/10/18

Job Completion



U 07-10-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D350-615	REV. B
DATE 97.10.21		TITLE GROUND HANDLING WHEEL MOD.	SHEET 2 OF 2
		SCALE	NTS

D2282-041 "T" ASSEMBLY

7/16-14-050C BOLT (1)
7/16-14NC LOCK NUT (1)
7/16WC WASHER (2)

5/16WC WASHER (REF)

5/16-18-015C BOLT (1)
5/16-18NC LOCK NUT (1)
5/16WC WASHER (4)
(3 PLACES)

EXISTING PUMP
BODY

D2282-043 SADDLE
ASSEMBLY

